

ASAP

Work Order ID 134986

July 23, 2015 9:55:10 AM

134986

Page 1

Item ID: D4037-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Crossbeam
 Start Date: 7/23/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/7/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SM **20150723** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4037	D								

100 0.00
100
 Waterjet Memo 0.00 (2) 02/15/08/06
 FLOW CNC Waterjet Cut blank as per file D4037-3_BLANK

110 0.00
110
 HAAS 1 Memo 0.00 2 Ø DAS
 HAAS CNC vertical machine #1 MACHINE AS PER FOLI FA878 AND DWG 40
 FOLIO REV: AA 9-89
 DWG REV: D 15/08/19
 DEBURR

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAJ/FAIB Memo	0.00 0.00				2	0		DAS 40 9-89 15/08/19
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				2	0		68-6 80 SVD D.C. 15/08/20
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	0	15-8-20	DAC

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 131545</i> Memo	0.00 START: 10:00 0.00 OEN. T: 320° FINISH: 10:30				2	0	15-8-21	DAS 34 9:00
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(2)			DAS 38 9:00 AUG 24 2015
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <i>SH471</i> Memo	0.00 0.00				2	DAS 6 9:00	AUG 24 2015	

DQA: _____ Date: _____



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Stop ***NS2***

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2

Cust Item ID:

Required Date: 8/7/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

AUG 24 2015

SH 120150824

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

July 23, 2015 9:55:49 AM

Page 1

Work Order ID: 134986

134986

Parent Item: D4037-3

D4037-3

Parent Item Name: Fwd Crossbeam

Start Date: 7/23/2015

Required Date: 8/7/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC IPP REV:D AS
PER ECN 11-554 11-05-24 JLM VERIFIED BY:DD IPP REV C:AS PER
ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.00 0		Purchased	No			100	f	31.5000	3.9	8.210526			

M6061T6B1 000X15 000

6061-T6 Bar 1.00 x 15.00

DL 15/08/06

Location

Loc Qty

Loc Code

MAT

31.5

m132360

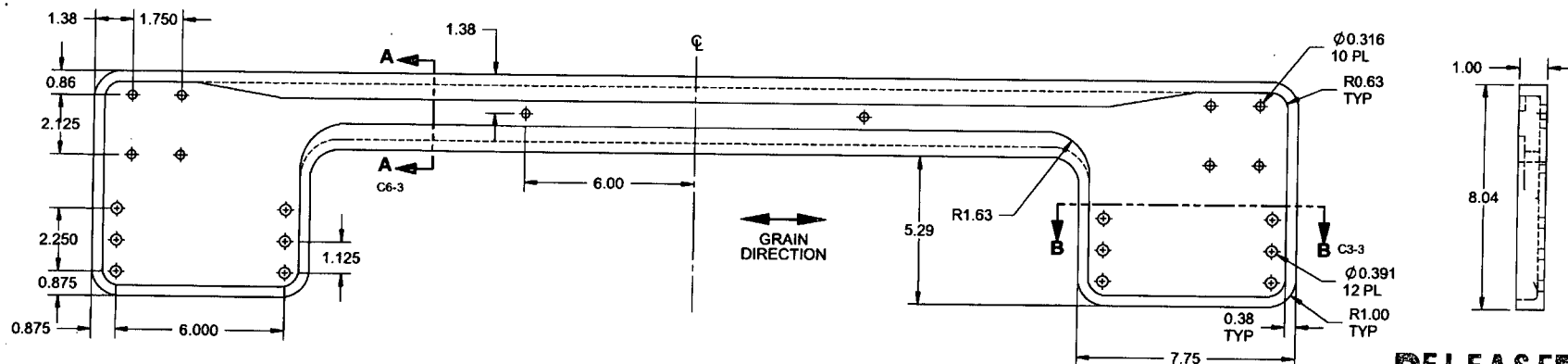
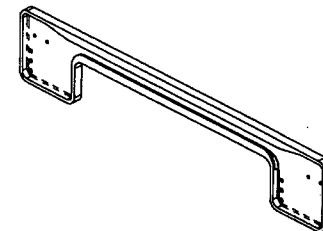
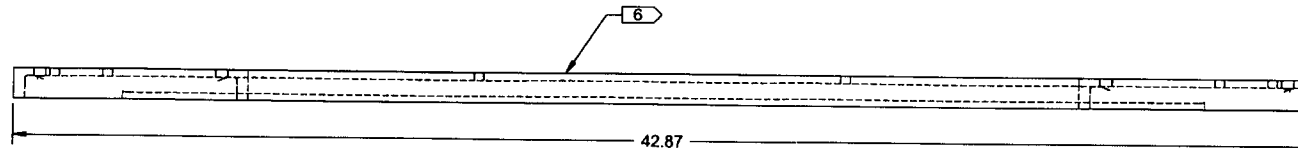
9

m132773

22.5

132894

8



D4037-1 AFT CROSSBEAM

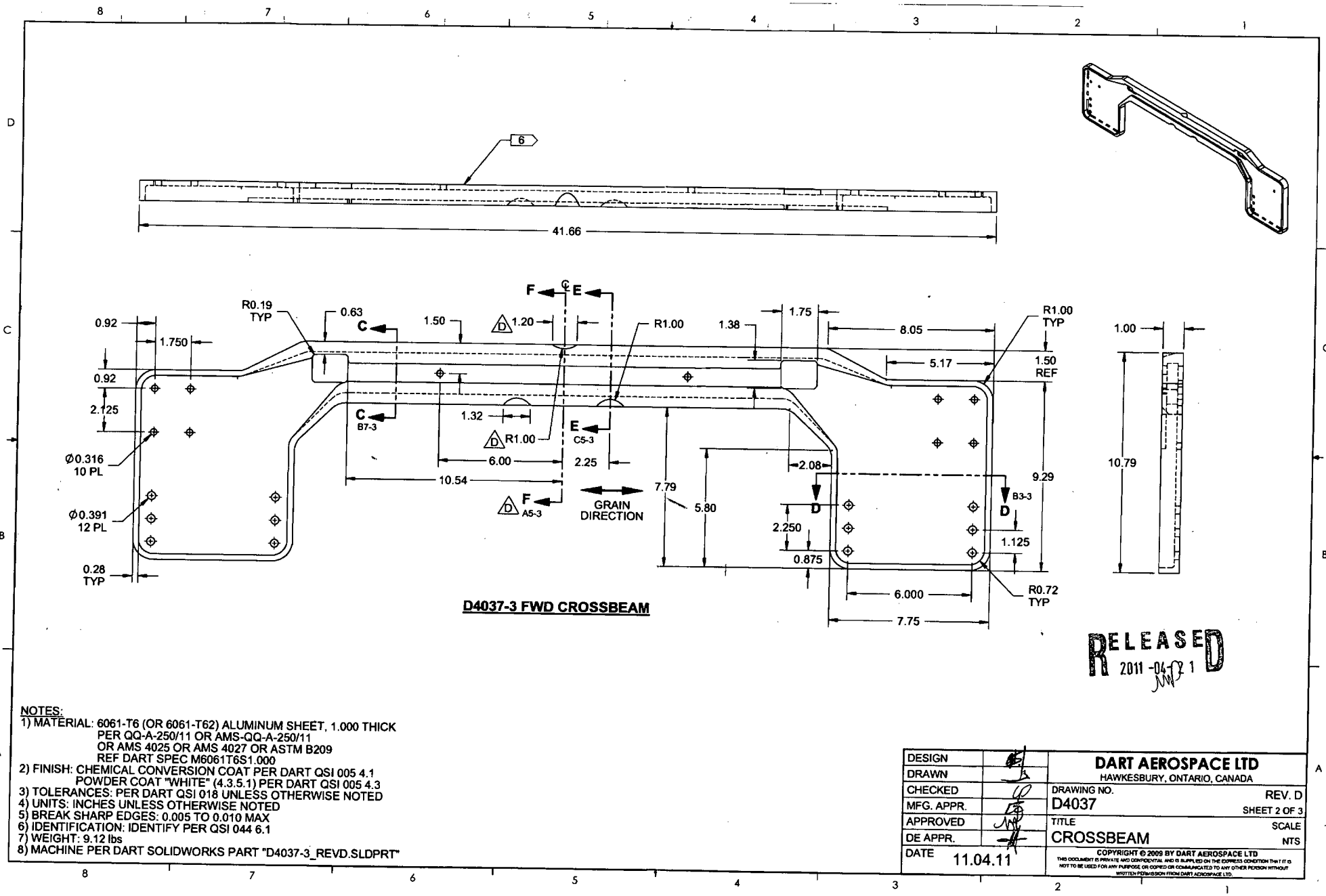
RELEASED
2011-04-23

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S1.000
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 8.48 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4037-1_REVD.SLDPRT"

D	MODIFY -3 PART FOR CLEARANCE. REF: NCR11-543.	MB	11.04.11
C	MODIFY -3 PART FOR CLEARANCE HOLES, SHT 2; UPDATE MATERIAL SPEC SHT 1, 2; 8.05 WAS 9.83; ADD GRAIN DIRECTION	HS	10.09.15
B	ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1, C8-2	HS	10.02.10
A	NEW ISSUE	HS	09.12.16
REV.	DESCRIPTION	BY	DATE

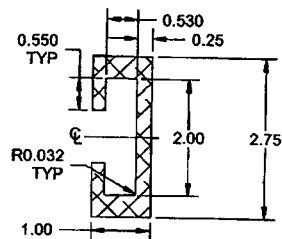
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4037 TITLE CROSSBEAM DATE 11.04.11
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.04.11	

REV. D	SHEET 1 OF 3
SCALE	NTS
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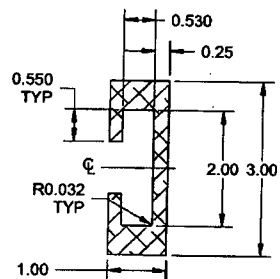


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 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 9.12 lbs
 - 8) MACHINE PER DART SOLIDWORKS PART "D4037-3_REV.D.SLDPRT"

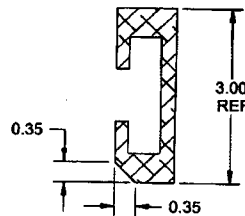
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. D
MFG. APPR.		TITLE	SCALE
APPROVED		CROSSBEAM	NTS
DE APPR.			
DATE	11.04.11		



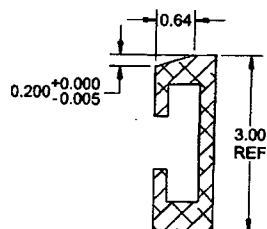
SECTION A-A B6-1
SCALE 2X



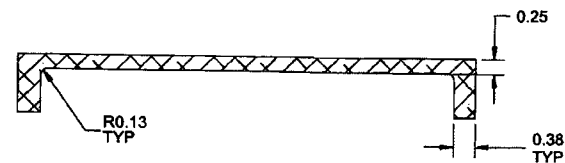
SECTION C-C B8-2
SCALE 2X



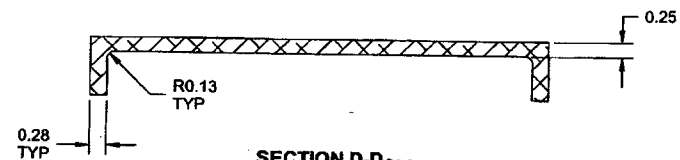
SECTION E-E C5-2
SCALE 2X



SECTION F-F B5-2
SCALE 2X



SECTION B-B B2-1
SCALE 2X



SECTION D-D B3-2
SCALE 2X

RELEASED
2011-04-11
JW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		CROSSBEAM	SCALE
DE APPR.			NTS
DATE	11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 137986
Description: Fwd Crossbeam		Part Number: D4037-3
Inspection Dwg: D4037	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	+/-0.030	41.66	✓		M Tape	
0.92	+/-0.030	0.916	✓		VCW	PHO-12
1.75	+/-0.030	1.750	✓		"	"
0.92	+/-0.030	0.916	✓		"	"
2.125	+/-0.010	2.120	✓		"	"
Ø0.316	+0.006/-0.001	0.316	✓		"	"
Ø0.391	+0.006/-0.001	0.392	✓		"	"
0.28	+/-0.030	0.283	✓		"	"
1.32	+/-0.030	1.305	✓		"	"
7.79	+/-0.030	7.790	✓		M G	31006
5.80	+/-0.030	5.800	✓		"	"
2.250	+/-0.010	2.252	✓		VCW	PHO-12
0.875	+/-0.010	0.875	✓		"	"
6.000	+/-0.010	6.001	✓		"	"
7.75	+/-0.030	7.750	✓		"	CNC-02
1.125	+/-0.010	1.125	✓		"	PHO-12
9.29	+/-0.030	9.287	✓		"	"
1.75	+/-0.030	1.749	✓		"	"
1.38	+/-0.030	1.375	✓		"	"
1.50	+/-0.030	1.500	✓		"	"
0.63	+/-0.030	0.628	✓		"	"
1.00	+/-0.030	1.012	✓		"	"
10.79	+/-0.030	10.780	✓		"	CNC-02
3.00	+/-0.030	2.999	✓		"	PHO-12
2.00	+/-0.030	2.009	✓		"	"
0.25	+/-0.030	0.269	✓		M G	RD-02
0.530	+/-0.010	0.531	✓		VCW	PHO-02
0.35	+/-0.030	0.351	✓		"	"
0.35	+/-0.030	0.351	✓		"	"
R0.13	+/-0.030	0.125	✓		Rat C	

Measured by:	40 9-89
Date:	15/08/19

Audited by:	M.A. DAS 08 9-89
Date:	15/08/20

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	10.10.07	Dimensions updated per Dwg Rev C	KJ	
C	11.06.21	Dwg Rev updated	KJ	